Required Date: 27/03/2012

Atem ID:

D350-636-011

Skidtube LH

Accept

N900040100

Revision ID:

Item Name: **Start Date:**

13/03/2012 Start Qty: 1.00

Date:

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Sequence ID/

Process Plan: MLJ Date: 12 03 14 Tooling:

Date:

Tool # Plan

Code

Run

Accept Reject

Qty

Qty

Operation

Reg'd Qty: 1.00

Date:

Number Stamp

Insp.

Work Center ID	Description
Draw Nbr	Revision Nbr
D2750	F
D3492	C `

100

DOCUMENT CONTROL

0.00

SPC (Y/N):

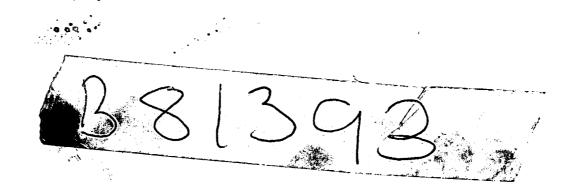
Set Up/

Run Hours

Document Control

Memo Photocopy blue file and type labels per PPP D350-636-011 CHG 006

Reject



Dart Ae	rospace	e Ltd						٠
W/O:			WO	RK ORDER CHANG	ES		- -	
DATE	STÉP	PR	OCEDURE CHAI	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Categ	ory:	_ NCR: Yes	No DQA:	Date: _	
	R	esolution:	Disposition	:	_ QA: N/C Cld	sed:	Date: _	
the state of the s			WORK ORDE	R NON-CONFORMA	ANCE (NCR)		
		Description of NC	Description of NC Corrective Action			Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
	,							

Page 2

March-14-12	':46:19 AM										
Item ID: Revision ID: Item Name:	D350-636-0	11		Accept	*N900)N4C	1100)* ፡	Setup Star Stop	ı	S1*
Start Date: Required Date	13/03/2012 : 27/03/2012	Start Qty: 1.00 Req'd Qty: 1.00	**	1 * 1 *	Cust Item Customer:					14	. 17
Reference:			·					ī	Run Star	† .L.B.I	5 4 4
Approvals:	Process Pla	in:	Date:			Oate:		•	Stop	"[7]	R1* R2*
Sequence ID/ Work Center I	D	Operation Description Skidtubes	_	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 Skidtubes		Memo 1- Pick D26	00-3 Bent	0.00					. <u> </u>		,
		AFT end per 3- Drill pilot deburr. 4- Locate D' fitting	tholes for blade fi	tting bolt holes using DT8983. Open efftting bolt holes and drill pilot holes using DT9016. Ensure proper positions are proper positions.	n to 0.500", es for blade						
		Jig DT8150 7- Clecko D' ***SECONI 8-Open up h location hole holes for gro	& DT8863A for f T8863B on second D SIDE*** oles for Detail B es to 0.500" (total and handling and	D2750 sheet 4 (D2750-1 details). Driest side only DT8863B for second sides and drill pilot holes for to 0.375" (4 holes per side) and blade of 4 holes per side) as per dwg D275 detail C to 0.500" (8 holes per side) es as per Dwg D2750 using DT8108	ide (detail B) r detail B. e fitting 0 .Open up		/		B 12/0	03/20	

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
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Dart No		PAR #:	Foult Cot	ogony.	NCP: Voc	No. DOA:		Data	
rail NO									
	Re	esolution:						Date:	
NCR:			WORK ORI	DER NON-CONFORMA	ANCE (NC)	4)			
DATE	OTED	Description of NC		ion B	Verifica	tion		Approva	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign a	& Section		Chief Eng	QC Inspecto
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QC

Quality Control

Page 3

March 14-12 7:46:19 AM D350-636-011 Accept Item ID: Setup Start *N900040100* Revision ID: Skidtube LH Item Name: 13/03/2012 Start Qty: 1.00 **Start Date: Cust Item ID: Required Date:** 27/03/2012 **Req'd Qty:** 1.00 **Customer:** Reference: Run Approvals: **Process Plan:** Date: Tooling: Date: SPC (Y/N): Date: Operation Sequence ID/ Tool ID Tool # Plan Reject Set Up/ Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 11-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: M/AO/ 12-Grind welds flush as per Dwg D2750 120 QC10- Inspect visual per QSI004- ground welds 0.00 0.00 QC Memo Quality Control 130 QC5- Inspect part completeness to step on W/O 0.00 *120*

0.00

Memo

W/O:		·	WC	RK ORDER CHAN	GES					
DATE	STEP	PF	OCEDURE CHAI	NGE	В	y	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
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	10									· . •
Part No	: 0	PAR #:	Fault Cate	Jory:	NCR: `	es N	o DQA	ı:	_ Date: _	
· ·	R	esolution:	Disposition	n:	QA: N/	C Clos	sed:		Date: _	<u>~</u>
NCR:		#B	WORK ORDE	R NON-CONFORM	ANCE (N	ICR)				
3.		Description of NC		Corrective Action Sec	ction B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & Date	Section		Chief Eng	QC Inspector
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Work Order ID 81393 March-14-12 7:46:19 AM Item ID: D350-636-011 Accept *N900040100* Setup Start Revision ID: Skidtube LH Item Name: Start Date: 13/03/2012 Start Qty: 1.00 **Cust Item ID: Required Date:** 27/03/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Approvals: **Process Plan:** Date: **Tooling:** Date: QC: SPC (Y/N): Date: Date: Accept *- Reject Sequence ID/ **Operation** Set Up/ Tool ID Tool # Plan Reject Insp. Work Center ID Description **Run Hours** Code Qty Numbér Stamp 140 Chemical Conversion Coat per QSI005 4.1 0.00 *140* HandFinish 0.00 Memo Hand Finishing 1 QC3- Inspect Part Finish 0.00 0.00 Memo Quality Control

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W/O:			WO	RK ORDER CHANG	GES	-				
DATE	STEP	F	PROCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	jory:	NC	R: Yes	No DQ	A:	Date: _	A. 1
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NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR)			
	T	Description of NC	Corrective Action Section B				Verific	ation		Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
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March-14-12 7:	46:19 AM										
Item ID: Revision ID: Item Name:	D350-636-0 Skidtube LH	11		Accept	*N900	040	100	* S	Setup Star	IN	S1*
Start Date: Required Date: Reference:	13/03/2012 27/03/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item 1 Customer:	ID:				, u	
Approvals:		in:	Date:	Tooling: SPC (Y/N):		ate:		F	Run Star Stop	"N	R1* R2*
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Skidtubes		Skidtubes Memo		0.00						لل المعادية المائد	·
Skidtubes		1-Open up side) as per dwg 2-Open up as per dwg	D2750. holes of Detail B to 0.7.	round handling to 0.625" (tol	al of 8 holes per		B	12/03	122		; ;
		4-Chamfer	• •	ound handling and float holes	s per dwg D2750			·			
		5-Deburr a	nd blow out all chips fro	m inside of tube					•		
	127	7-Bond we A/R Sik	e	OSI 015 M 12 05 i 3 xp. date: _ i 2 - 0 3/2 2							
		(welding ir A/R Alun	structions on sheet 8)	3 and D2743 as per dwg D27 20/64 spacer to 0.404"	7 / /	3					
	g.	10-Grind w	velds flush as per Dwg D	2750	Bl 12f03/2 UT1.	203	-26				

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W/O:			W	ORK ORDER	CHANGES				1	1
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Part No	:	PAR #:	Fault Cate	egory:	N	CR: Yes	No DQA	۷:	Date: _	<u>.</u>
•	R	esolution:	Disposition	on:	Q	A: N/C CI	osed:		Date: _	* ***
NCR:	* * .	W	ORK ORD	ER NON-CO	NFORMANO	CE (NCR)		igos ad	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action De	scription	Sign &	Verific Section		Approval Chief Eng	Approval QC Inspector
			Office Eng		Eng	Date				
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Process Plan:

Operation

Description

QC:

Approvals:

Sequence ID/

Work Center ID

		813	93						Page 6
1		Accept	*N90	೧ ೧4೧	100*	Setup		*N	S1*
							Stop	*N:	S2*
y: 1.00	*1*		Cust Iter	m ID:					
ty: 1.00	*1*		Custome	er:					
	Date:	Tooling:		Date:			Start	*N	R1*
	Date:	SPC (Y/N):		Date:			Stop	*N	R2*
n on 11-Spot face g	ground handling holes se	Set Up/ Run Hours ction (total of 4 places per	Tool ID	Tool#	Code Qty	Qty	N	Reject Iumber	Insp. Stamp
dwg D2750					C 12/03	126	34 35 38 38	ī,s	
12-Deburr hole	es					e Trees in the		Karana da karana	
	QSI004- ground welds	0.00	7/27						
Memo		0.00							

12-Deburr holes 170 QC10- Inspect visual per QSI004- ground welds *170* 0.00 Memo Quality Control QC5- Inspect part completeness to step on W/O 0.00 QC 0.00 Memo Quality Control

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W/O:			W	ORK ORDER CH	ANGES			•	ı	• 🗸
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Part No	:	PAR #:	Fault Cate	egory:	NC	R: Yes	No DQ	A:	Date:	
	R	esolution:	Disposition	n:	QA	WC CI	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFO	PRMANCE	(NCF	R)			
		Description of NC		Section B Verification			ration	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Descrip Chief Eng	otion	Sign 8 Date		on C	Chief Eng	QC Inspector
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Work Orde		393		*813	393*			Page 7
Item ID: Revision ID: Item Name:	D350-636-0 Skidtube LH	11		Accept	*N900040	100*	Setup Start	14.71
Start Date: Required Date: Reference:	13/03/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:		·	*NS2*
Approvals:	Process Pla	in:	Date:	Tooling: SPC (Y/N):	Date:		Run Start Stop	"INK1"
Sequence ID/ Work Center II 190 *100* HandFinish Hand Finishing	•	Operation Description Pressure Wash per QSI00 Memo Re-alodine to		Set Up/ Run Hours 0.00 0.00 on 4.1.2.1 do not acid etch.	Tool ID Tool #	Plan Acco Code Qty	Qty	Reject Insp. Number Stamp
200 *200* Powdercoat Powder Coating	ro ogg	White Gloss(Ref:4.3.5.1) Memo START TIM OVEN TEM FINISH TIM	E:	0.00 0.00 1	lX	1 / m	-L 12/1	3/30
210 *210* QC Quality Control		QC7-Inspect Chemical Co	onversion Coat	0.00		 	— J	U-ulogla

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W/O:			W	ORK ORDER CHANG	ES			٠.
DATE	STEP	PRO	CEDURE CH		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:						
	R	esolution:	_ Disposition	on:	_ QA: N/C CI	osed:	Date: _	· · · · · · · · · · · · · · · · · · ·
NCR:		, W	ORK ORE	ER NON-CONFORMA	NCE (NCR)		
DATE	STEP	Description of NC		Corrective Action Section	the state of the s	Verification	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Work Order ID 81393 March-14-12 7:46:19 AM		*81393*									Page 8	
Item ID: Revision ID:	D350-636-0	11		Accept	*N900	040	100)*	Setup S	Start	*N	S1*
Item Name:	Skidtube LH								9	Stop	*N	S2*
Start Date:	13/03/2012	Start Qty: 1.00	*1*		Cust Item I	D:						
Required Date: Reference:	27/03/2012	Req'd Qty: 1.00	*1*		Customer:							
Approvals:	Process Pla	in:	Date:	Tooling:	Da	ate:			Run S	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:			S	Stop	*N	R2*
Sequence ID/ Work Center II 220)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
220		HandFinishing		0.00				11/	XN	1	110	1.1
HandFinish Hand Finishing		Memo 1- Install ins	erts as per Dwg D2750	0.00			•		<i>) : </i>	12	- ()	104/02
230				0.00								
230		HandFinishing										
HandFinish		Memo		0.00								
Hand Finishing		1-Inspect for	Foreign Objects	~/\~								
•		2-Spray insid	de of tube with "LPS-3"	batch:								
		3-Install blac per dwg D27 SIKA FLEX BATCH: EXP DATE:	150 241 MIQQ	earshoes and ground handling	ng hardware as							
		4-assemble o	ring to plug as per dwg	D3492 and apply o'ring lub	e							

A/R 55-o'ring lube batch: W110348
5-Coat all exposed fasteners with "LPS Procyon" batch 114596

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Part No	:	PAR #:	Fault Cate	gory:	NC	R: Yes	No DQ	A:	Date:	
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DATE	OTED	Description of NC		·-·	tion B		Verification		Approval	Approval
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Work Order ID 81393 Page 9 March-14-12 7:46:19 AM Item ID: D350-636-011 Accept *N900040100* Setup Start **Revision ID:** Item Name: Skidtube LH 13/03/2012 Start Qty: 1.00 **Start Date: Cust Item ID: Required Date: 27/03/2012 Req'd Qty:** 1.00 **Customer:** Reference: Run **Process Plan: Approvals:** Date: __ _ Tooling: Date: QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool # Plan Set Up/ Reject Accept Reject Insp. **Work Center ID Description** Run Hours Code Qty Number Stamp **Qty** 240 QC5- Inspect part completeness to step on W/O *240* QC Memo Quality Control 250 Pick Kit 0.00 *250* Packaging 0.00 Memo Packaging 260 QC4- 100% Inspect kits for completeness 0.00

QC

Quality Control

Memo

*****ensure antiseize is on AN8C21A bolts*****

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DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	•	PAR #:	Fault Cate	jory:	NCR: Yes	No DQ	\:	Date: _			
Resolution:			Disposition	1:	QA: N/C CI	osed:		Date: _			
NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Se	ction B	Verific	ation	Approval Chief Eng	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section			QC Inspector		
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Quality Control

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NCR:			WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Se			erification	Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng			Section C	Chief Eng	QC Inspector				
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Picklist Print

March-14-12 7:46:23 AM

Work Order ID: 81393

81393

D350-636-011

D350-636-011

Parent Item Name:

Skidtube LH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

Parent Item:

IPP Rev:I 02.09.25 Rearranged procedure steps KJ IPP Rev:J 06-03-23 As per Rev D JLM

IPP Rev:K 06-07.13 As per dsi9343 EC

IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec

IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010 DD verf:EC IPP Rev:P 10.06.22 revise

seq110 DD verf:EC

IPP Rev:Q 10.10.01 as per IIN revH

DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Ki	t Total Qty	Qty Date Status Issued Issued
D3492-1		Manufactured	No			230,	Each	130.0000	8	8	
D3492-1									**	MI	12/04/02
				Location		Loc	Oty	Loc Code		,	. ,
				FP002			130				
					69531		8				
					74444		2				
					76235		20			_2	
					77037 🗸		100				
D3492-3		Manufactured	No			230	Each	69.0000	8	8	
D3492-3									**	ml	12/04/02

 Location
 Loc Qty
 Loc Code

 FP-A
 69

 78600
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Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _					
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NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section	on B	Verification	1 Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector				
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March-14-12 7:46:23 AM						·	Page 2
Work Order ID: 81393	*8	1393*		-			·
Parent Item: D350-636-011		350-636-	∩11*				
Parent Item Name: Skidtube LH	,	.).)()=().)()=	(711			Date: 13/03/2012 t Qty: 1.00	Required Date: 27/03/2012 Required Qty: 1.00
NAS1611-010 Purchased	No		230	Each	209.0000	8 8	
NAS1611-010			1211	66	*		1/ 12/04/02
		<u>Location</u>	Lo	c Oty	Loc Code	8	. 11
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		110915 120770		0 50			
		FP001		159			
		110915		14			
		117460		8		~	
		118077 118612		3			<u> </u>
		119438		47			
		120308		36			
NAS1140D00731		120986		50			
NAS1149D0863J Purchased	No		250	Each	231.0000	2 \mathbf{L}	1,1
NAS1149D0863.1					*	* 4	12/4/2
		Location	Lo	c Oty	Loc Code	\	
		ST298		231			
		118078		36 05		<u> </u>	
		<u>119307</u> 120308		95 100		2	<u> </u>
D2744 Manufactured	No		110	Each	60.0000	1 1	
D2744					*:	•	n - 1 / 1
Cap							BE12/03/22
		Location	Loc	e Qty	Loc Code		
		LG002		60			
		62715		1			
		70881 71861		10			_
		78900		7 42			
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DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	Res	olution:	Disposition):	QA: N/C	Closed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NO	CR)			
DATE	STEP	Description of NC			tion B	Sign & Verification		Approval	Approval
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Work Order ID: 81393 Parent Item: D350-636-011 Parent Item Name: Skidtube LH			1393* 350-636-0)11*			tart Date: Start Qty:	13/03/2012	Required Date: 27/03/2012 Required Qty: 1.00
D2600-3-BENT *D2600-3-RFNT* Extrusion Bent	Manufactured	No		110	Each	26.0000	**		B12/03/26
			Location LG 66875 73253 75021 75022 75023	<u>L</u>	26 7 1 1	Loc Code			
D2743 *D2743* Crossbolt Spacer	Manufactured	No	81330	160	15 Each	248.0000	8 **	8	- BE12/03/23
			Location LG001 67766 68251 73403 74445 78603 79517	<u>L</u> c	248 4 3 64 1 76 100	<u>Loc Code</u>		8	
D2739 *D2739* 3501Beam	Manufactured	No		160	Each	8.0000	1 **	1	St 1203-22
			Location LG 72155 80083	<u>Lo</u>	8 1 7	Loc Code			

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W/O:			WC	RK ORDER CHANC				, etc.	* \>
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Dat	e Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	jory:	NCR: Ye	s No	DQA:	Date: _	
	Resolution:		Disposition	:	QA: N/C	Closed:	! <u></u>	Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	CR)			
DATE		Description of NC			tion B	V	Verification Approva		Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n &	Section C	Chief Eng	QC Inspector
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Picklist Print March-14-12 7:46:23 AM	,									Page 4
Work Order ID: 81393		*81	1393	3*						
Parent Item: D350-636-011 Parent Item Name: Skidtube LH		*D	350	-636-0 ⁻	11*			tart Date: Start Qty:	13/03/2012 1.00	Required Date: 27/03/2012 Required Qty: 1.00
D3490-3	Manufactured	No			160	Each	38.0000	4	4	, , ,
D3490-3 Cross Bolt Spacer	·							**		& E 12/03/23
			Locatio	<u>n</u>	Lo	oc Qty	Loc Code			/ /
			LG001			38				-
D3490-1	Manufactured	No		78800	160	38	40.0000		4	-
D3490-1 Cross Bolt Spacer	Manufactured	140			100	Each	49.0000	**	4	BE12/03/23
2000 2000 Sp. 1000			Location	<u>n</u>	<u>Lo</u>	e Qty	Loc Code			/ /
			LG001			49				
				62450		2				· -
				74875 770 4 2		4 3				-
				78793		40			4	-
ALS4-1032-225	Purchased	No			220	Each	1,134.000	38	38	•
AI S4-1032-225								**	mit	12/04/02
			Location	<u>1</u>	Lo	c Qty	Loc Code		, ,,,	
			ST281			1021				
				108696 110768		146 62				
				118386		55				
				118966		68			38	
			ST282	120671		690				
			31282	120410		113 100				
				120451		13				

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W/O:		· · · · · · · · · · · · · · · · · · ·	W	ORK ORDER CHANG	GES				*
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	<u> </u>	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date: _	
Resolution:			Disposition	on:	QA: N/C C	losed:		Date: _	
NCR:			WORK ORE	ER NON-CONFORM	ANCE (NC	R)			
		Description of NC		Corrective Action Sec	tion B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
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March-14-12 7:46:23 AM									Page 5
Work Order ID: 81393 Parent Item: D350-636-011 Parent Item Name: Skidtube LH			1393*)350-636-0	11*		Start	Date:	13/03/2012	Required Date: 27/03/2012
						Start			Required Qty: 1.00
D3793-3 *D3793-3* Wearshoe	Manufactured	No		230	Each	26.0000	1 *	M	12/04/02
			Location FP001 80434 FP002	<u>L</u> c	12 12 12 14	Loc Code			
*AN8C35A *AN8C35A* BOLT	Purchased	No	78935	230	14 Each	65.0000	1 *	ml	12/01/20
			Location FP002 115960 117834 118286 ST346 114442 115188 115960	<u>Lo</u>	64 1 10 53 1 0 0	<u>Loc Code</u>			12/04/02
D3793-1 *D3793-1* Wearshoe	Manufactured	No	•	230	Each	0000.81	! :	Mh	12/04/02
			Location FP001 77029 78901	<u>Lo</u>	18 6 12	<u>Loc Code</u>			•

	<u> </u>	<u>ld</u>					 	<u> </u>
W/O:			WO	RK ORDER CHANGES	S			
DATE	STEP	PR	OCEDURE CHAN	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQA:	Date: _	
	Reșc	olution:	Disposition	:	QA: N/C CI	osed:	Date: _	
NCR:			WORK ORDE	R NON-CONFORMAN	CE (NCR	R)		
		Description of NC		Corrective Action Section		Verification	Approval Chief Eng	Approval QC Inspector
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		
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Work Order ID: 81393 Parent Item: D350-636-011 Parent Item Name: Skidtube LH			1393* 350-636-0	11*	··· · · · · · · · · · · · · · · ·			13/03/2012	Required Date: 27/03/2012
D3488-041	Manufactured	No		230	Each	17.0000	art Qty: 1	1.00	Required Qty: 1.00
D3488-041 Blade Fitting Assembly, LH	Manaractured			230	Lacii		**	m-l	12/04/02
			Location FP002 61689 75056	Loc	17 1 7	<u>Loc Code</u>		-	
D3794-3 *D3794-3* Gasket	Manufactured	No	77021	230	9 Each	31.0000	l **	m-1	12/04/02
AN6C44A			Location FP002 74530 78895 80436		31 2 5 24	Loc Code			
AN6C44A BOLT	Purchased	No		230	Each	107.0000	4 **	4	12/04/02
			Location FG 103964 ST343 120095 120143 120465 120641 121013	<u>Loc</u>	Oty 2 2 105 12 25 27 21 20	<u>Loc Code</u>			109102

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W/O:			WC	ORK ORDER CHANGE	S		· <u>^</u> .	- · - *
DATE	STEP	PROC	CEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								,
Part No):	PAR #:	_ Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
	R	esolution:	_ Disposition	n:	QA: N/C CI	osed:	Date: _	
NCR:		W	ORK ORD	ER NON-CONFORMA	NCE (NCF	R)		······································
DATE	STEP	Description of NC	Corrective Action Section B			Verification	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	1 Section C	Chief Eng	QC Inspector
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Work Order ID: 81393 Parent Item: D350-636-011 Parent Item Name: Skidtube LH		393* 50-636-0 <i>1</i>	11*		Start Date: 13/03/2012 Required Date: Start Qty: 1.00 Required Qty:		
*M\$21083C8 *M\$21083C8*	Purchased	No		230 Each	85.0000 **	1 M-1	12/04/02
		\$	Location FP002 115884 ST303 115884 118077 119309 119436 119638 ST304 120142 120731 121011	Loc Qty 1 1 14 0 1 2 9 2 70 20 25 25	Loc Code		-
*D3536-25 *D3536-25* Gasket	Manufactured		Location FP002 78902	230 Each Loc Oty 16 16	16.0000 1 ** Loc Code	1 	12/04/02
D3631-1 *D3631-1* Washer	Manufactured		Cocation ST072 68062 75548	230 Each Loc Oty 223 2 221	223.0000 8 ** Loc Code	8 M-L	12/64/02

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W/O:			WC	RK ORDER CHAN	GES					
DATE	STEP	PR	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
Part No):	PAR #:	Fault Categ	Jory:	NCF	R: Yes	No DQ	A:	Date: _	
	Re	esolution:	Disposition	ı:	QA:	N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	IANCE	(NCR)			· · · · · · · · · · · · · · · · · · ·
DATE	STEP	Description of NC		ction B		Verification		Approval	Approval	
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspecto
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Work Order ID: 8 Parent Item: D Parent Item Name:	1393 9350-636-011 Skidtube LH			1393* 350-63	66-01	11*			tart Date: 1		Required Date: 27/03/2012 Required Qty: 1.00
D3791-1 *D3791- Wearplate	1*	Manufactured	No			230	Each	17.0000	! * *	M	12/04/02
ANI060C 101	NACUMOCO222		N.	Location FP002 62239 75041 78897			17 2 3 12	Loc Code			
*AN960C10L *AN960 <i>C</i> washer	NAS1149C0332 R	Purchased	No			230	Each 3 3 5 4	0.0000	38 **	38 38_1	m.L 12/04/02
D2745 *D2745* Bushing		Manufactured	No			230	Each	136.0000	8 **	8 -M-J	m/ 12/04/02
				<u>Location</u> FP 79518 FP001		<u>Lo</u>	c Oty 100 100 36	Loc Code		3	- ,

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W/O:			WC	RK ORDER CHANGE	S			<u>*</u>
DATE	STEP	PR	OCEDURE CHAI		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):	PAR #:	Fault Categ	gory:	NCR: Yes	No DQA:	Date: _	1
	R	esolution:	Disposition	n:	QA: N/C Cl	osed:	Date: _	
NCR:			WORK ORDE	ER NON-CONFORMAI	NCE (NCR)		
DATE	OTED	Description of NC		Corrective Action Section		Verification	Approval Chief Eng	Approval QC Inspector
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		
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Picklist Print March-14-12 7:46:23 AM							Page 9
Work Order ID: 81393 Parent Item: D350-636-011 Parent Item Name: Skidtube LH	.		1393* 350-636-01	1*	Start Date:	13/03/2012	Required Date: 27/03/2012 Required Qty: 1.00
AN3C5A Bolt	Purchased	No		230 Each	998.0000 34 **		12/04/02
			Location FP001 115835 ST350 116419 117343 117764 117872 119749 120423	Loc Oty 7 7 991 28 13 7 2 23 918	Loc Code	34	
D3537-I *D3537-1* Wearpad	Manufactured	No	120423	230 Each	151.0000 3 **	M_{\perp}	12/04/02
			Location FP001 79833 79835 FP002 69817 79834	Loc Oty 104 50 54 47 5	<u>Loc Code</u>	3	, ,,
*NAS1149C0832R *NAS1149C0832F WASHER	Purchased ? *	No	Location ST297	230 Each Loc Oty 304 304	304.0000 1 ** Loc Code		12/04/02

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W/O:			WC	RK ORDER CHANGES	-		- -	·· -
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Part No		PAR #:						
	H	esolution:					Date: _	<u> </u>
NCR:			WORK ORDE	R NON-CONFORMAN	CE (NCR	(1)		
		Description of NC		Corrective Action Section B	3	Verification		Approva
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspecto
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Work Order ID: 81393		*8	1393*					·	
Parent Item: D350-636-011 Parent Item Name: Skidtube LH			350-636-0	11*		C.		12/02/2012	
· State of the sta							rt Date: irt Qty: [13/03/2012 1.00	Required Date: 27/03/2012 Required Qty: 1.00
AN3C6A	Purchased	No		230	Each	623.0000	4	4	
AN3C6A						•	**	M-1	12/04/02
			Location	Loc Qt	<u>y</u>	Loc Code		,	11-
			FP001		1				
			111982		1				_
			ST351	63	22				_
			111982		2				_
•			116419 116549	-	23				_
			116704		2 12				-
			117619		10				_
			117688		1				_
			117872		5				_
			118422		13				_
			119449		21				- -
			120423		33			4	·
NAS1611-013	D 1 1	NI.	120693	40					_
	Purchased	No		230	Each	168.0000	8	8	
NAS1611-013						7	**	Mil	12/04/02
			Location	Loc Qt	Ł	Loc Code		,-	v
			FP001	16	58				_
			116582		5				_
			117291		2				_
			117887 119623		3			-	_
			120360		16 12			-	-
			120910		50			-	_
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W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CHAI		Ву			Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):	PAR #:	Fault Categ	gory:	NCR: Ye	es No	DQA:	_ Date: _	
	Res	olution:	Disposition	n:	_ QA: N/C	Closed	l:	Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (N	CR)			
DATE	STEP	Description of NC		Corrective Action Section E			Verification	Approvai	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n&	Section C	Chief Eng	QC Inspector
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Work Order ID: 81393		*813	93 *						
Parent Item: D350-636-011 Parent Item Name: Skidtube LH			60-636-0)11*			rt Date: art Qty:	13/03/2012	Required Date: 27/03/2012 Required Qty: 1.00
D3535-25 *D3535-25* Wearshoe	Manufactured	No		230	Each	19.0000) **	1 -M-L	12/04/02
		<u>Lo</u> FP(62233 80331	<u>Lo</u>	14 1 1 13 5	Loc Code		- -	- - -
D3794-1 * D3794-1* Gasket	Manufactured	No	77617	230	5 Each	24.0000	1 **	m-f	12/04/02
		<u>Lo</u> FP(cation 002 75042 80435	<u>Lo</u>	24 12 12	Loc Code			· - -
MS21043-6 *MS21043-6* _{NUT}	Purchased	No		230	Each	809.0000	4 **	mh	12/04/02
		Eo FG ST:	103693	<u>Lo</u>	20 20 789 83 6 200 500	Loc Code		4	- / / V

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W/O:			WC	RK ORDER CHANGE	S		***	
DATE	STÉP	PRO	OCEDURE CHAI	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
·		•			3			
Part No):	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
	R	esolution:	Disposition	n:	QA: N/C CI	osed:	Date: _	
NCR:		1	WORK ORDE	R NON-CONFORMA	NCE (NCF	1)		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	Sign 8	Verification Section C	Approval Chief Eng	Approval QC Inspector

Picklist Print March-14-12 7:46:23 AM										Page 12
Work Order ID: 81393 Parent Item: D350-636-011 Parent Item Name: Skidtube LH			1393*)350-636-()11*			art Date: tart Qty:	13/03/2012	Required Date: 2 Required Qty: 1	
D3493-1 - *D3493-1* Washer	Manufactured	No		250	Each	66.0000	2 **	2		
-			Location ST050 70697 		t <u>y</u> 66 2 24 40	Loc Code		2	- - -	
MS21083C8 *MS21083C8* NUT	Purchased	No	70033	250	Each	85,0000	2 **	2	- 50	
AN8C21A *AN8C21A*	Purchased	No	Location FP002 115884 ST303 115884 118077 119309 119436 119638 ST304 120142 120731 121011		ty 1 1 1 1 2 9 2 70 20 25 25 Each	<u>Loc Code</u>	2 **	2		
BOLT			Location ST343 118758 120094 120872		У 51 5 42 4	Loc Code		2	- - - -	· · · · ———
March-14-12 7:46:23 AM			Shop P	acket Print						Page 12

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W/O:			WC	ORK ORDER CHANG	ES		· · · ·	
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
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			=					
Part No):	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA:	Date: _	
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NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR	3)		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	on B Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 81393 Parent Item: D350-636-011 Parent Item Name: Skidtube LH			1393* 350-636-0	11*	-		tart Date: Start Qty:	13/03/2012	Required Date: 27/03/2012 Required Qty: 1.00
*NAS1515H3L *NAS1515H3L * WASHER	Purchased	No		230	Each	184.0000	* * *	4 M-1	12/04/02
			Location FG 102472 ST277 118686 119438 120072 120360	<u>L</u>	40 40 444 3 1 40 100	Loc Code		4	
D2741 *D2741* Blade, 350 Skidtube	Manufactured	No		250	Each	37.0000	† **	1 5	
			Location ST ST466 71856 76984	<u>L</u>	-10 47 1 36	<u>Loc Code</u>			
D3532-1 *D3532-1*	Manufactured	No	•	250	Each	39.0000	2 **	12/4/3	SP
			Location ST053 78839	Lo	39 39	Loc Code		2	

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					·					
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Part No	:	PAR #:	PAR #: Fault Category:					\:	Date: _	
	Resolution: Disposition:						ed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	MANCE (N	CR)				
DATE	STEP	Description of NC		ection B	0	Verific		Approval	Approval	
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•	QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
•	-041 X	-042	-043	-044		
	├^ -	X			D2750-041	350 SKIDTUBE ASSEMBLY, LH
			-		D2750-042	350 SKIDTUBE ASSEMBLY, RH
	<u> </u>		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
				X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
	1	1	-	1	D2739	WEB
	8	8	8	8	D2739 D2743	SPACER
				1	D2743	CAP
	- 1 8	8	8	8	D2744 D2745	BUSHING
		8	8	8	D2745 D2750-1	
	1					SKIDTUBE WELDMENT, LH
	ļ	_1_			D2750-2	SKIDTUBE WELDMENT, RH
			1		D2750-3	SKIDTUBE WELDMENT, LH
				1_	D2750-4	SKIDTUBE WELDMENT, RH
	1_1_		1		D3488-041	BLADE FITTING, LH
		1		1_1_	D3488-042	BLADE FITTING, RH
	4	4	4	4	D3490-1	SPACER
	4	4			D3490-3	SPACER
			4	4	D3490-5	SPACER
	8	8	8	8	D3492-041	PLUG ASSEMBLY
	8	8			D3492-043	PLUG ASSEMBLY
			8	8	D3492-045	PLUG ASSEMBLY
	1	1	1	1	D3535-25	WEARSHOE
^	1	1	1	1	D3536-25	GASKET
Æ	3	3	3	3	D3537-1	WEARPAD
	8	8	8	8	D3631-1	WASHER
Γ	1	1	1	1	D3791-1	WEARPLATE
J	1	1	1	1	D3793-1	WEARSHOE
^ - '	1	1	1	1	D3793-3	WEARSHOE
Æ i	1	1	1	1	D3794-1	GASKET
	1	1	1	1	D3794-3	GASKET
-						
Æ	38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
L	34	34	34	34	AN3C5A	BOLT
_	4	4	4	4	AN3C6A	BOLT
	4	4	4	4	AN6C44A	BOLT
	1	1	1	1	AN8C35A	BOLT
^	38	38	38	38	AN960C10L	WASHER
(E)	1	1	1	1	AN960C816L	WASHER
_	4	4	4	4	MS21043-6	NUT
	1	1	1	1	MS21083C8	NUT
	4	4	4	4	NAS1515H3L	WASHER
						1::::::::

GENERAL NOTES:

MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).

FINISH:

ACID ETCH, ALONDE ASSEMBLY PER DART OSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.

POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: N/A

BREAK SHARP EDGES: N/A
IDENTIFICATION: N/A
WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
WELD PER DART OSI 004
INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM YIELD TENSILE STRENGTH = 38 KSI
SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER

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D	ADD HO	DLES AND SPA	PH	06.01.05			
С	ADD D2	750-3/D2750-4	CP	98.11.18			
В	CHANG	E MS24694-S2	CP	98.09.01			
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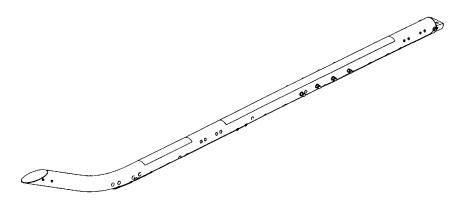
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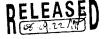
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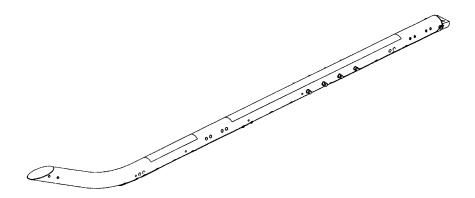


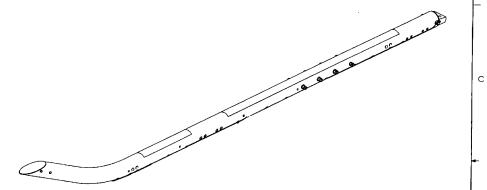
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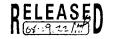
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D2750-044 350 SKIDTUBE ASSEMBLY, RH



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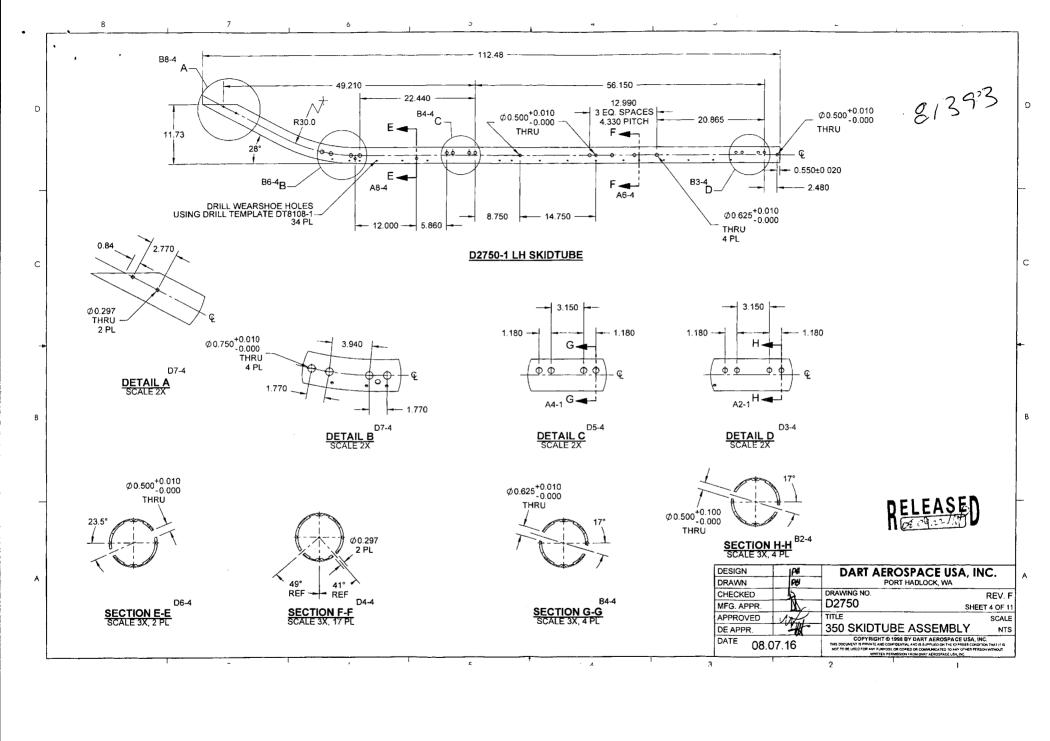
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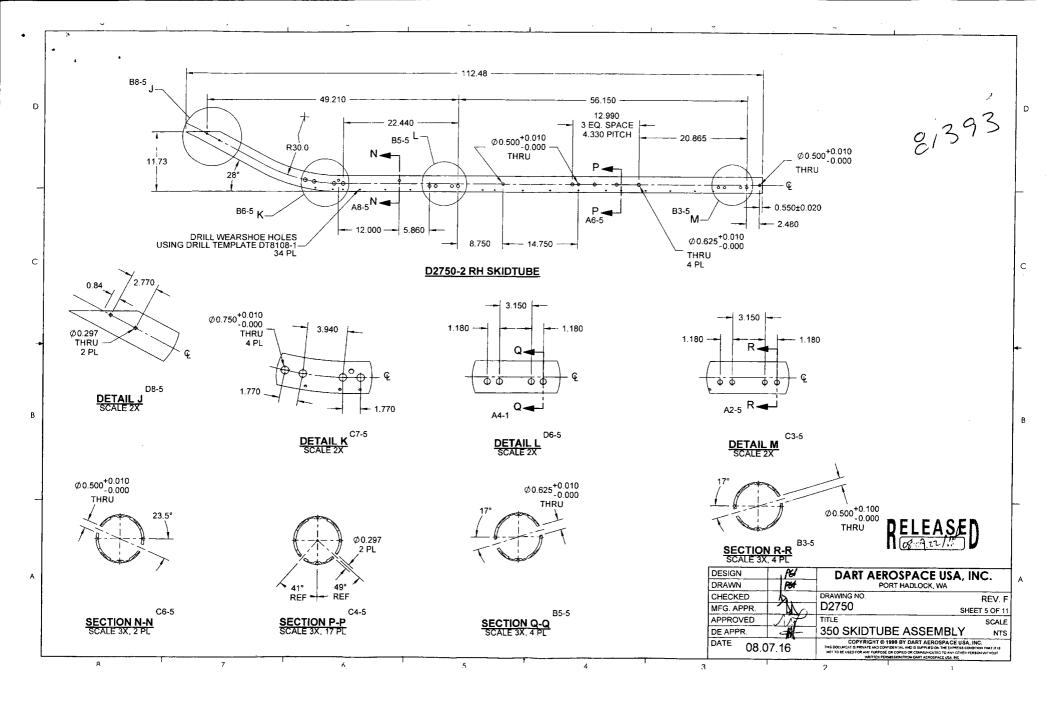
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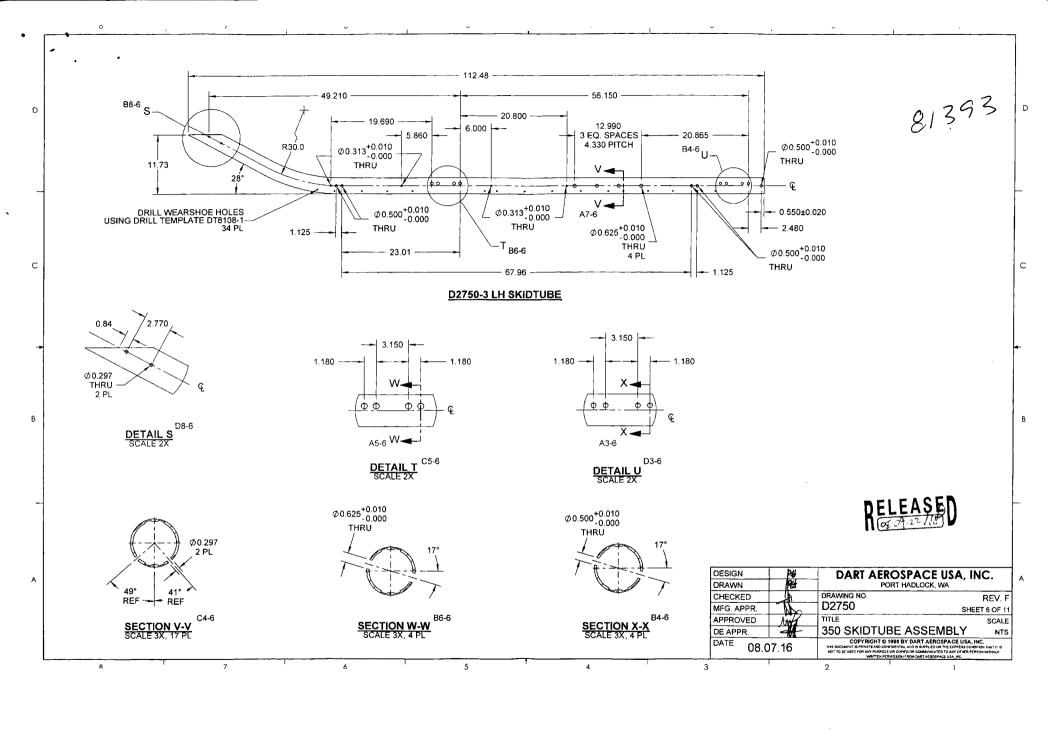
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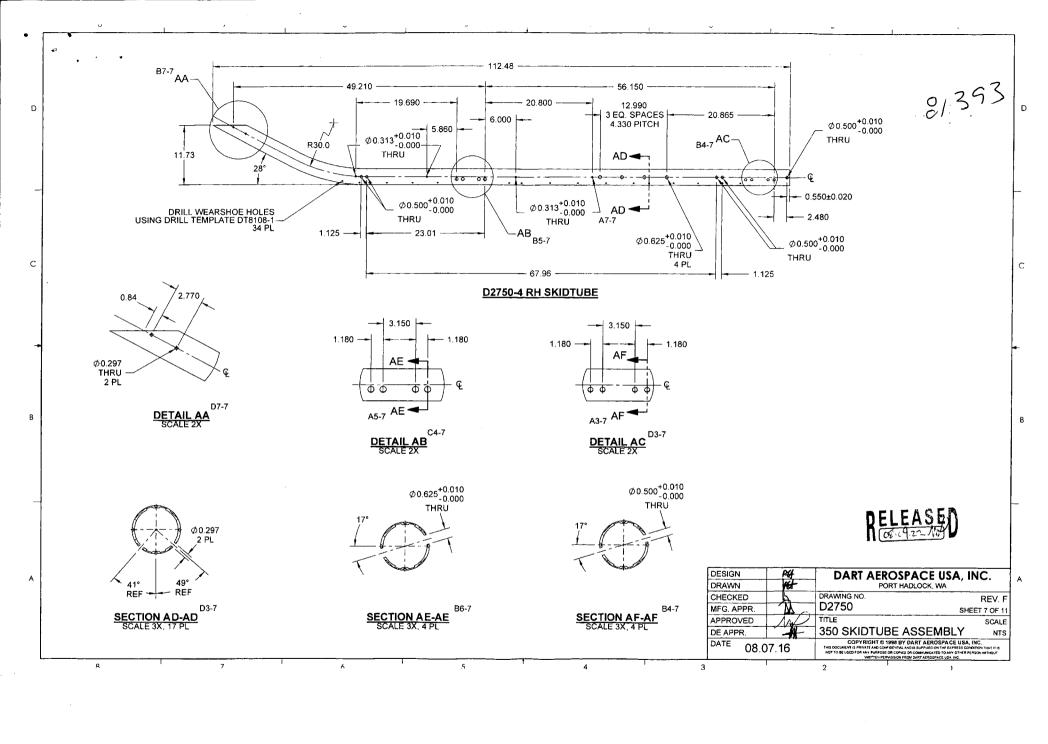
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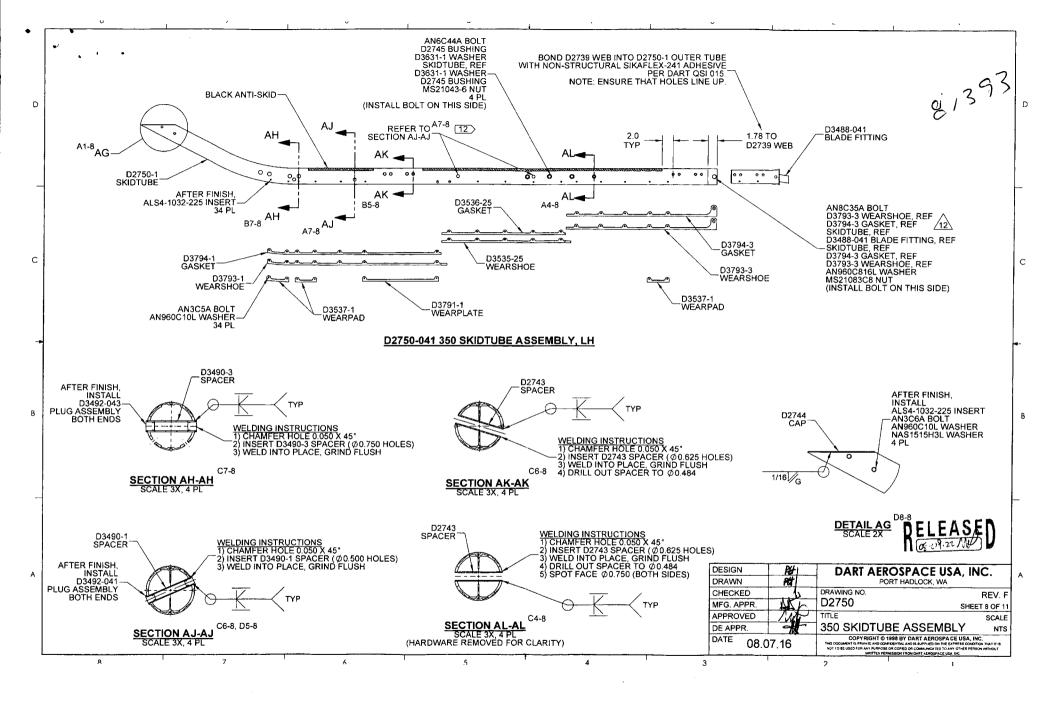
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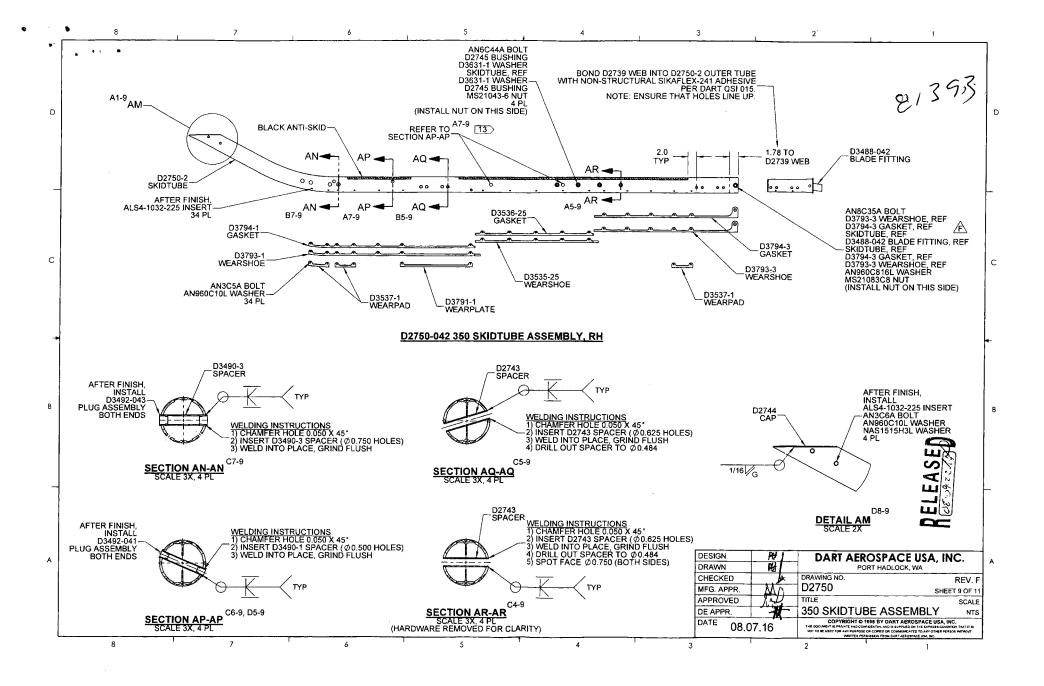
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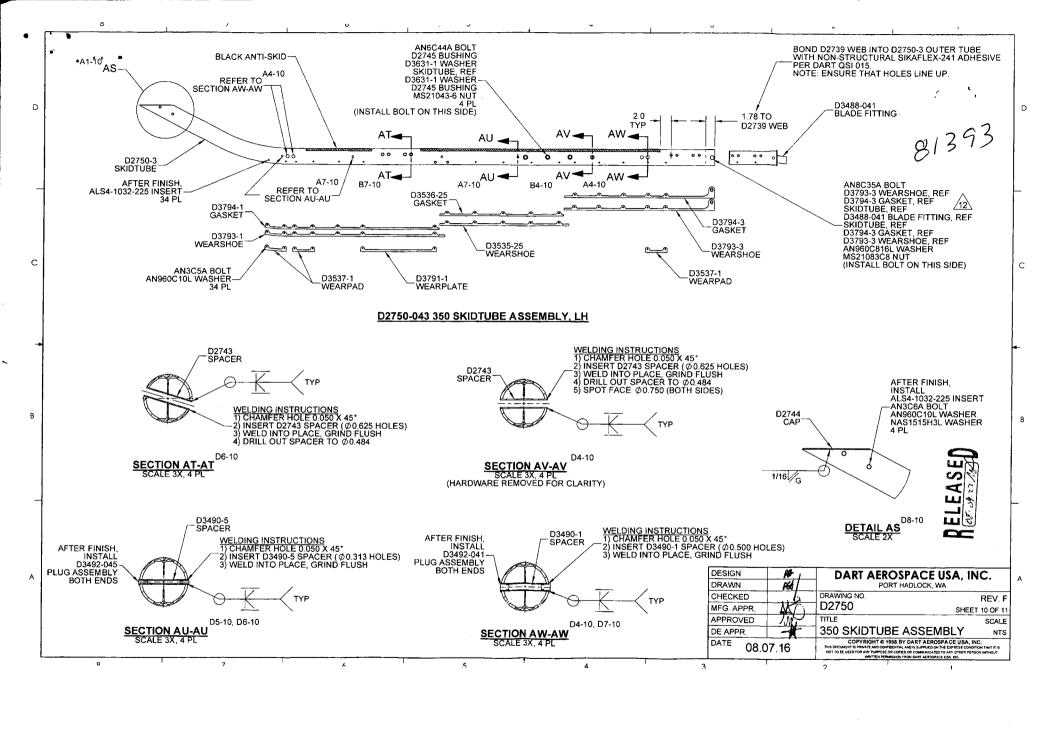
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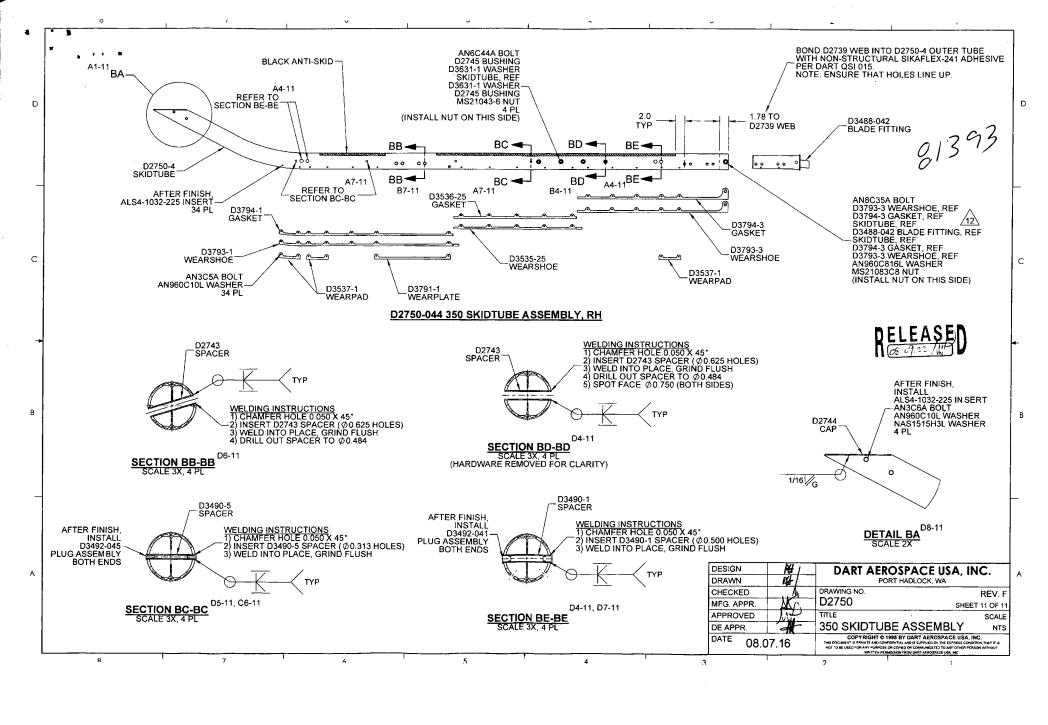
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AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Briclay E	Hiat
Job number:	70///2
Part number: \$350-63	36-011
Description: Skidto	56 U//
Welding Process: Tig[Mig	
	Mun
Current: AC[]	
TEST]	REQUIREMENTS AND RESULTS
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***	6.7 6.315.3
Visual:	pass[] fail[]
Penetration:	pass[/ fail[]
UNACCEPTABLE	
	/ .
Cracks:	pass[fail[]
Undercut:	pass[fail[]
Pin holes:	pass[] fail[]
Overlap (cold lap)	pass[fail[]
Porosity (surface):	pass[1] fail[1]
- 1	
Coloration:	pass[] fail[]
1 . 1 . 0	
Qualifier Jana Bulle	Date of Test Coupon 12.02.01
Welder Barclay Elist	Date of Test Coupon /2.03.0/
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The above named individual is qualified in accordance with AWS D17.1.2001 to weld